

ABSTRACT

A method for producing casting cores and/or casting molds is provided. The core shooter and/or molding machine (1) has at least one shooting unit (2) including a shooting head (4), filled with a material to be shaped (50),
5 especially a mixture of core or molding sand with a binder. The mixture is shot into a molding tool (100) by supplying pressurized air through a shooting board (5) which includes at least one shooting opening (6). At least one moveable mixing tool (7) is disposed in the shooting head (4) and is used to mechanically loosen the material to be shaped (50) present in the shooting
10 unit (2) before, during or after shooting.